

DART AEROSPACE LTD	Work Order:	21965
Description: D3307-041 Access panel	Part Number:	D3307-041
Dwg:	Qty:	2

Page 1 of 1

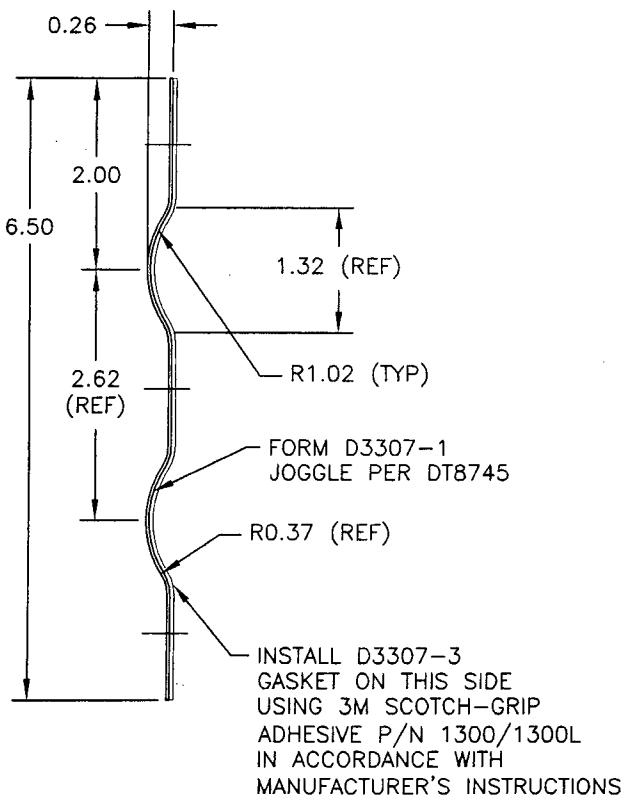
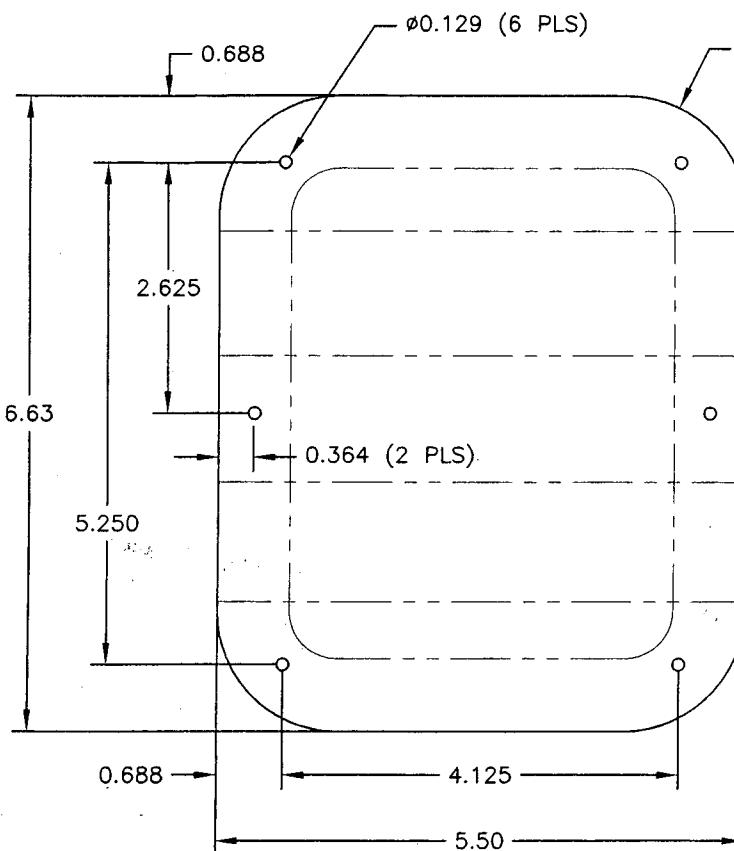
Step	Location	Procedure	By	Date	Qty
1	DC	Issue Travelled	AB	04.11.24	2
2A	GA	Cut blank size as per Dwg D3307-1 M14883 (40)	AB	04.11.24	2
2b	GA	Drill holes as per Dwg D3307-1	AB	04.11.24	2
3	GA	Bend using DT 8745	AB	04.11.24	2
4	GA	Deburr	AB	04.11.24	2
5	GA	Cut Gasket as per Dwg 3307-3 using D3245 (20774) ^(size specified)	AB	04.11.24	2
6	GA	Bend Gasket using A/R 1203/1201 H15604	AB	04.11.24	2
7	GA	Transfer drill holes through gasket	AB	04.11.24	2
8	QC5	Inspect level 5	RF	04.12.01	2
9	ST	Weld S/s & stack	AB	04.12.01	2
10	AC	Cost 1.31 Cost/Part: .87	SAC	08-01-07	2
11	DC	Close w/o Inspect level 21	AB	05.01.12	2

Rev	Date	Change	Revised By	Approved
A		New issue		



DESIGN 	DRAWN BY 	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED 	APPROVED 	DRAWING NO. D3307	REV. A	SHEET 1 OF 2
DATE 04.09.23		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:2	
A	04.09.23	NEW ISSUE		

MI4883



D3307-1 PANEL FLAT PATTERN

D3307-041 BEND DETAIL

**IDENTIFY WITH P/N & B/N
USING FINE POINT
PERMANENT MARKER**

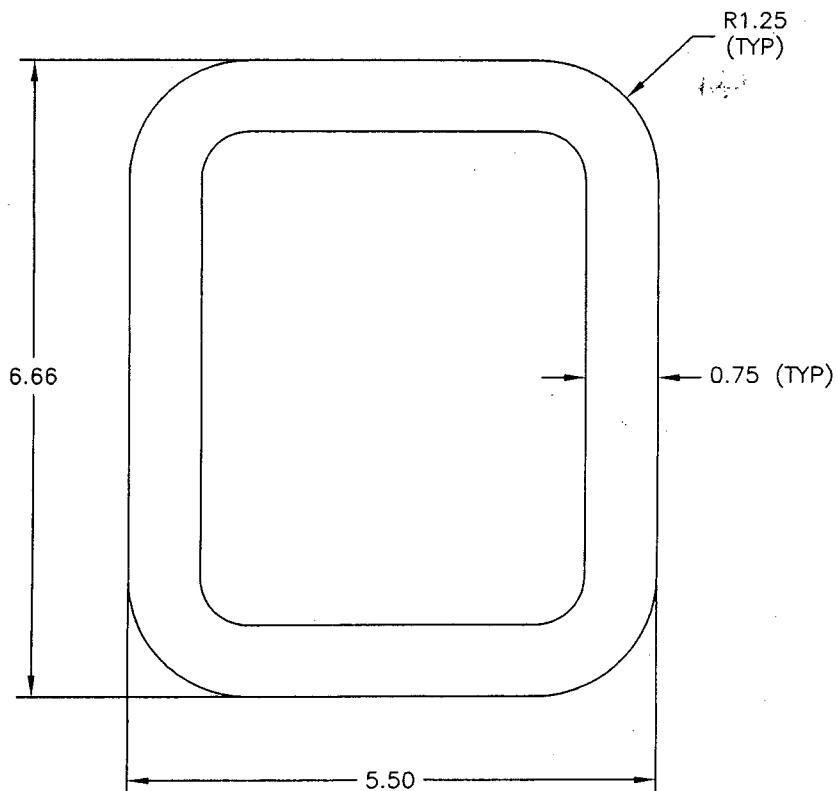
D3307-1 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK ANNEALED (REF. M304S22GA)
 - 2) FINISH: NONE
 - 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) ALL DIMENSIONS ARE IN INCHES
 - 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

REFERENCE ONLY

DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3307	REV. A SHEET 2 OF 2
DATE 04.09.23		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:2

**D3307-3 GASKET****D3307-3 NOTES:**

- 1) MATERIAL: DURABLA BLACK GASKET 0.035 THICK MIL-A-7021C OR MIL-A-17472B (CLASS 1 & 2) OR MIL-G-12803A (GRADE P-1161A)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

REFERENCE ONLY**Copyright © 2004 by DART AEROSPACE LTD**

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.